

Date: Tuesday, 7/17/2007 1:59:32 PM  
User: Kim Johnston

# Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 33580	
Estimate Number : 12577	
P.O. Number :	Part Number : D3562042
This Issue : 7/17/2007 S.O. No. :	Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : KC
Previous Run : 32721	Material :
Written By :	Due Date : 8/3/2007 Qty: 1 Unit: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 06-11-09 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

10 D26221-10C Extrusion



Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Qty	Part #	Description	Batch
1	D2622-120C	Extrusion	B32858

Check Material for any Dents or Defects

20 D2734 206 Step Endplate



Comment: Qty: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick	Qty/Part Number	Description	Batch
	2 D2734	End Cap	B33861

07.10.02 1

30 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

07.07.24

2-Deburr and bevel ends for welding

07.07.24

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

Step # 3





Date: Tuesday, 7/11/2007 1:59:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC9

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC9

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D3560012

ARM WELDMENT



Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

B 32645

9.0

D3560014

ARM WELDMENT



Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

Batch: B 32648

10.0

MS20600AD4W5

Blind Rivet



Comment: Qty: 36.0000 Each(s)/Unit Total: 216.0000 Each(s)

Blind Rivet

batch: M 8953 (16) M 105125 (16)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. Touch up alodine.

Rivet legs using Magnabond as per dwg D3562.





Date: Tuesday, 7/1/2007 1:59:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

Ensure to wipe off any excess magnabond of the step

A/R

Magnabond 6398

Batch: M104677

KE 07-10-02 1

12.0

QC5

INSPECT WORK TO CURRENT STEP



checked on Helicopter



Comment: INSPECT WORK TO CURRENT STEP

ED 2/10/02

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M103794

KE 07-10-02 1

2-Grind end cap welds flush as per Dwg D3562

KE 07-10-02 1

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-02 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ED 2/10/02

16.0

POWDER COATING

POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

WJ 07-10-02 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105694

M-K 07/10/02

(IX)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ED 07/10/02

IBS \* SEE W/D CHG

\* QCAS

ED 07/10/02

(P/D) ->



Date: Tuesday, 7/17/2007 1:59:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 33580

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick. Assembly Kit

*Draft*

*7/10/12 SC*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



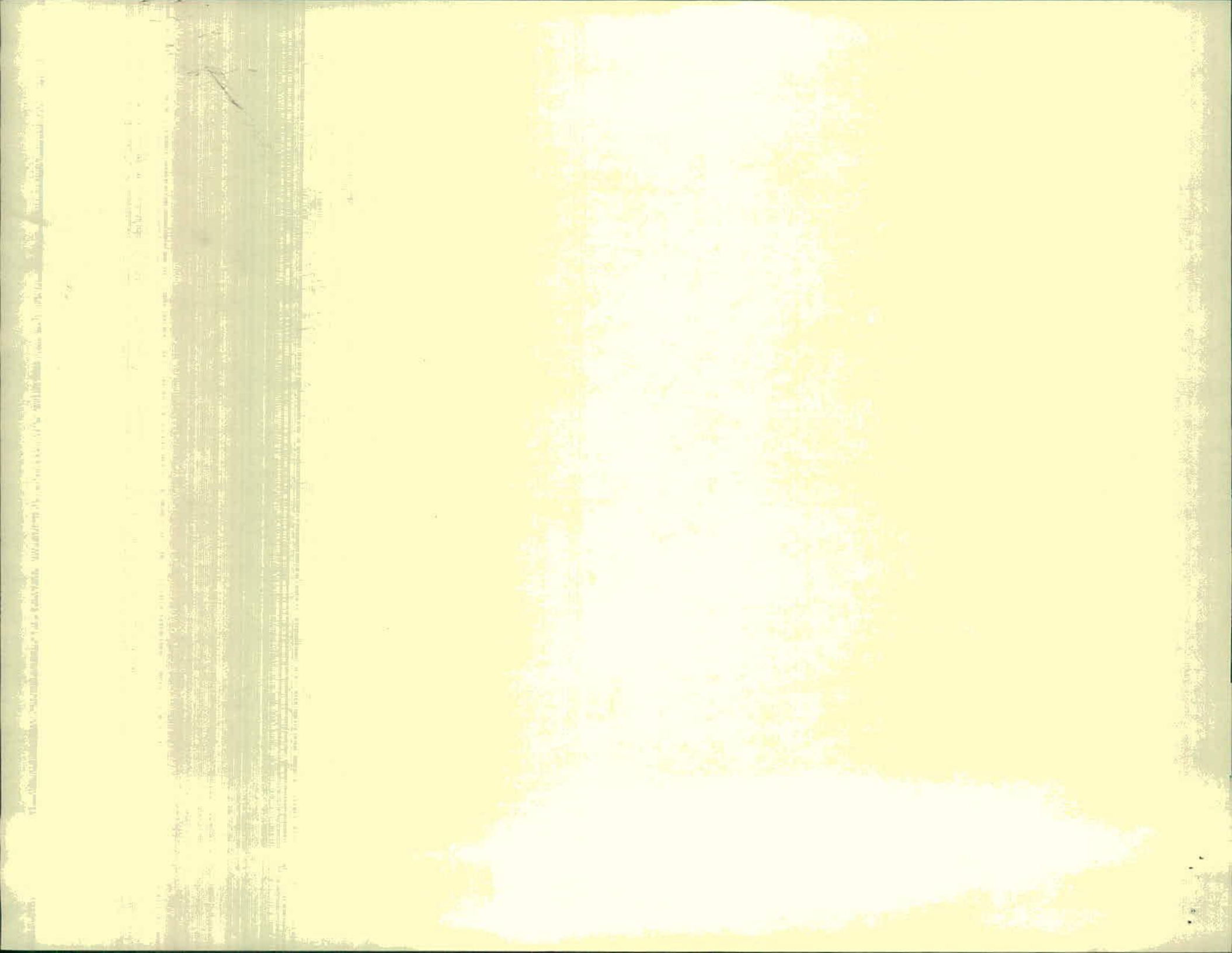
*07.10.02*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



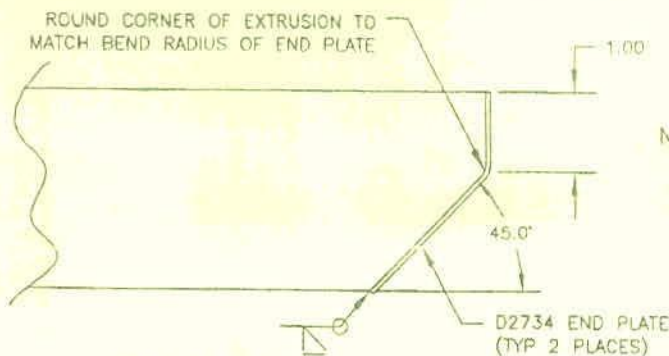






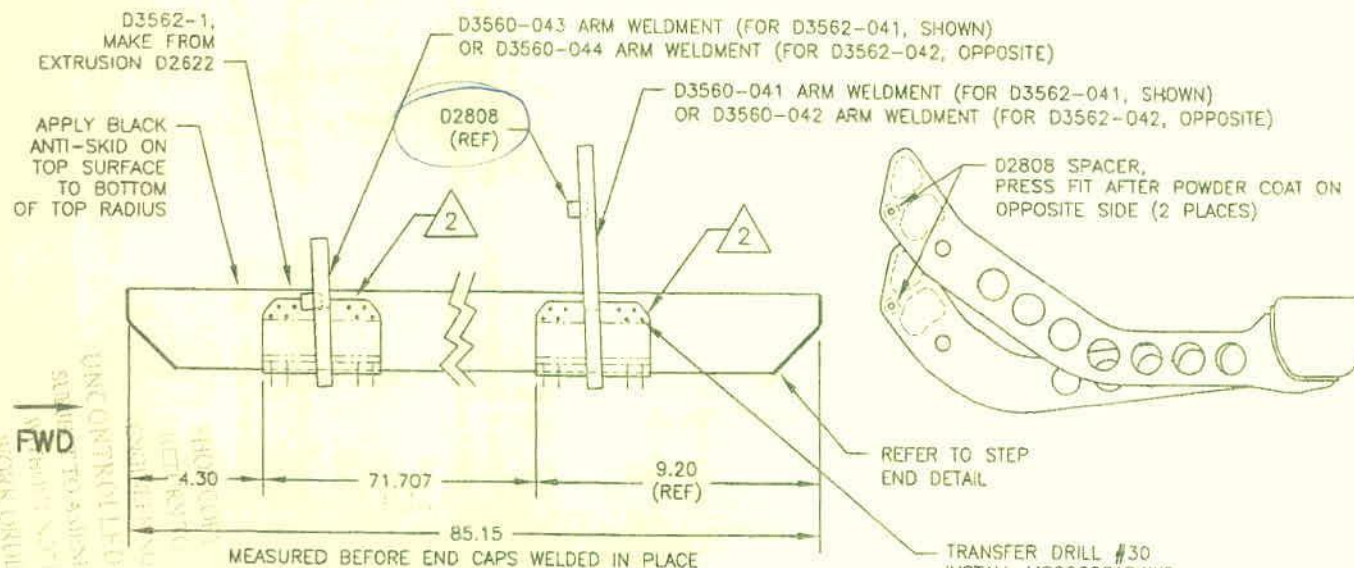
**DART**

**RELEASED**  
07.06.21



**TYPICAL STEP END DETAIL**  
NOT TO SCALE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES


DESIGN	DRAWN BY	TITLE	REV. 2
07.06.21	07.06.19	D3562	07.06.19
CHECKED	APPROVED	DRAWING NO.	REV. 2
07.06.21	07.06.19	D3562	07.06.19
DATE	DATE	TITLE	REV. 2
07.06.19	07.06.19	STEP ASSEMBLY	07.06.19
A	06.09.26	NEW ISSUE	07.06.19
B	07.01.15	ARMS NOW RIVETED TO STEP	07.06.19
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVT	07.06.19

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/02	18	ADD 2 D2808 B32752 inspect QCS	SB	07/10/02	1		
		EO 07/00/02. ←					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



